

Date: Monday, 2/19/2007 8:08:03 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARPAD
Job Number	30758		
Estimate Number	12711		
P.O. Number	N/A	Part Number	D35373
This Issue	2/19/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3537 UNDER REVIEW Rev A 07.02.19
First Issue	N/A	Project Number	N/A
Previous Run	N/A	Drawing Revision	U/R
Written By		Material	N/A
Checked & Approved By	<u>07.02.19</u>	Due Date	2/26/2007
Comment	Est Rev:A New Issue 07-02-14 JLM	Qty:	12
Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 0.1512 sf(s)/Unit Total : 1.8144 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>M101034 M101873 M1 07 03 01</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> <u>SAD 07/03/01</u>		
2-Deburr if necessary (12)		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SAD 07/03/01</u> (12)		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>07/03/02</u> (12)		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158 <u>SB 07/03/05</u> (12)		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/31/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:08:04 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 30758

Part Number: D35373

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg ~~D3429~~ D3537 M# 07.0219

M 07/03/12 (12)

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
07.02.19 20593 APR500 Hardcoat M02755
Weld hardcoat as per Dwg ~~D3429~~ D3537

FC 07/03/12 (12)

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 07/03/12 (12)

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 07/03/12 (12)

10.0 POWDER COATING

POWDER COATING



M101601

(12x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-f

07/03/15

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Grey 03/15 (12) f

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Boys 03/15 (12) f

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

S 07/03/15

Job Completion



4 07/03/16

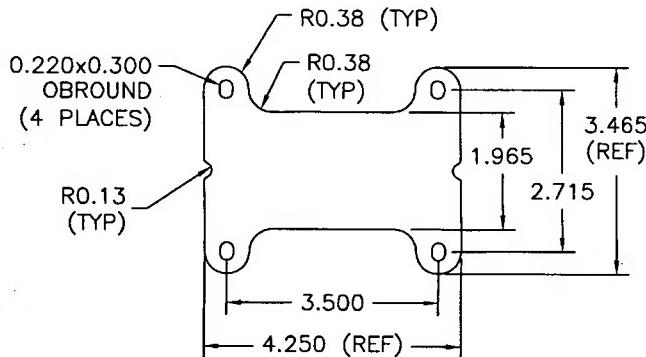
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

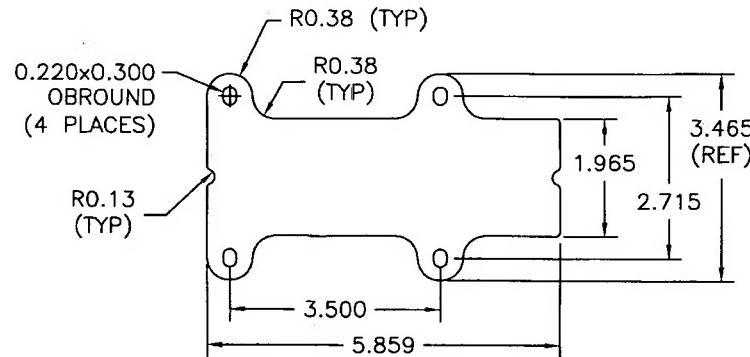
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

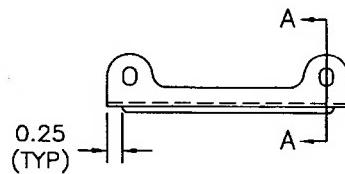
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

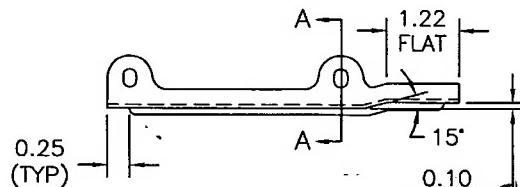


D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)

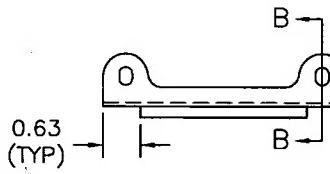


RELEASED
07.01.12

D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



NOTES

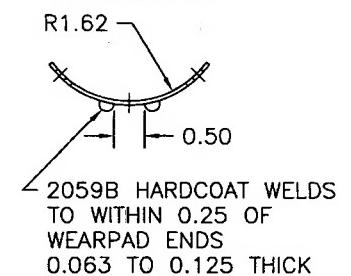
- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE (0.063 THICK, REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CB	CB	
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3537
DATE	TITLE	REV. A
06.11.06	WEARPAD	SHEET 1 OF 1
SCALE 1:2		

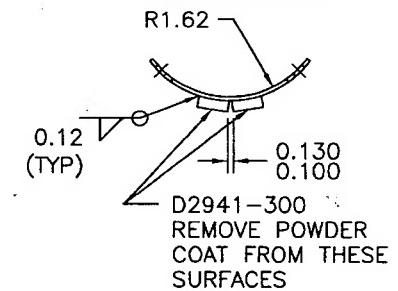
SHOP COPY
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ENGINEERING
NO. 20758
WORK ORDER
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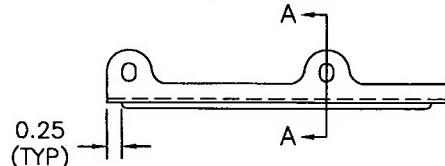
SECTION A-A



SECTION B-B



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



DART AEROSPACE LTD	Work Order:	30758
Description:	Part Number:	D35373
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<i>SAA</i>	Audited by:	<i>AD</i>	Prototype Approval:	
Date:	<i>07/03/01</i>	Date:	<i>07/03/02</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	